Basic surface preparation

For best adhesion, bonding surfaces should be:

• Clean—remove loose, chalky or flaky coatings, and contaminants such as grease, oil, wax, and mold release.
• Free of dirt, dust, and other loose material.
• Clean, dry, don’t sandpaper before bonding. Do not use laudanum rags to apply or remove solvents as they may contaminate the surface with fabric rennizer.
• Sanded—smooth and non-porous surfaces with 80-grit aluminum oxide sandpaper to provide good texturization for the ‘key’ to the bond.

Although G/Flex 650 Epoxy can be used to bond most plasti cs, it appears to provide the greatest benefit to polyethylene. If you are unsure of the type of plastic, it doesn’t hurt to flame treat.

Hardwoods, including tropical woods

Bonding to dry wood (between 6 and 12% moisture content) is best for achieving long-term reliable bonds. Sanding surfaces with 80-grit parallel to the grain. Clean oily woods with a solvent such as acetone, lacquer thinner, or isopropyl alcohol. Apply solvent with white paper towels to the bonding surface before solvent is used. Do not use laudanum rags to apply or remove solvents.

Disposable paper towels in a temperate climate act like a dehumidifier to develop a toughened epoxy that was simple to handles epoxy and basic tech-

Mixing and curing

Dispense equal volumes of G/Flex 650 Resin and Hardener. Pour 32 fl oz-G/flex 650 Epoxy, 8 fl oz-G/flex 650 Epoxy, and immediately scrub metal surfaces through the inside corner of the joint. Use of a mixing stick or plastic spreader is essential. Bonding to damp or wet surfaces (see Data Range) can be used with G/Flex 650 Epoxy when fiber reinforcement is used.

When parts are joined at or near right angles, fillets can be approached the area has been saturated, use the spreader to smooth and re-apply epoxy after the cure. Repeat the process with additional Surface preparation

Surface preparation for various dry materials

Material Basic surface preparation Additional surface preparation

Fiberglass terminus

Aluminum

Steel

Sanded 860 Aluminum Etch, two part

Wood

Metal-Enhanced

Copper

Lead

ABS

Polyurethane

Polyethylene (LDPE, HDPE, etc.)

Polystyrene

Sand with medium-grit sandpaper


Gougeon Brothers Inc. is a registered trademark of Gougeon Brothers Inc. G/Flex 650 Epoxy is the latest addition to the WEST SYSTEM line of epoxy products. While G/Flex 650 Epoxy provides phys- ical properties different than WEST SYSTEM 105 Resin-based epoxies, they share the same high performance as WEST SYSTEM epoxies in general durability, high water resistance, and chemical resistance.

West System is the world’s leading brand of marine epoxy, create the best solution for builders, boatyards, and other engineers interested in producing high-quality, high-performance products. It is the world’s leading brand of marine epoxy for use in fiberglassing/wood/epoxy boat building. We know the engineering and construction technologies and procedures used in the manufacture of our products are the best in the world. Weston Systems, 1-800-225-6854 toll-free, is the number one choice for builders and repair projects.

For the most recent news and information, visit westsystem.com. WEST SYSTEM technical publications will help assure the success of your building and repair project. WEST SYSTEM is committed to your building and repair project. WEST SYSTEM technical publications and videos provide detailed procedures and insights into all aspects of epoxy application, from surface preparation to consideration. Our goal is to create a product that satisfies the needs of the boatbuilder, whether it be a small repair job or a major refit. Our West System products are designed to give you a professional-quality finish on all your projects. West System products are designed to give you a professional-quality finish on all your projects.

Ask for the Free Literature Pack and you will receive the User Manual & Product Guide, as well as 402-025 Epoxy. Other Literature Pack will help you make the decision on how to use West System products. Further assistance can be obtained by contacting your knowledgeable and friendly Technical Staff. Send an e-mail to west@wes-tech.com or call 1-800-225-6854 toll-free.

Fiberglass Boat Repair & Maintenance Technical Staff. Send an e-mail to west@wes-tech.com or call 1-800-225-6854 toll-free.
Pliofilm and lap joints

Flame treat HOPE and LOPE (high-density and low-den.
ity polyethylene) plastic with a propane torch to provide adhesion. See Special surface preparation on the reverse of this page.

Mix an appropriately sized batch of G/Flex 650 Epoxy and add 400 Filler in a ratio of 3:1.

Apply a bead of the thickened epoxy to the beveled joint, overlapping slightly.

Cover the epoxy filled joint with 2” wide cellophane plastic taping. Tape down the excess (overfill) epoxy to wet out the fiberglass cloth. If necessary, a heat gun can be used to warm the epoxy and improve wet out of the fiberglass cloth. Use a spreader to smooth out any air bubbles or “fish-eyes” on the surface.

Small hole repair

Cannas and kayaks are often dragged over sand and rocks, resulting in worn off ends and eventual leaks near the bow and stern.

Apply G/Flex Epoxy and 406 Filler to any damage to the beveled joint with a small spreader or stiff brush.

Mix enough G/Flex 650 Epoxy to wet out and apply one or two layers of fabric.


to the surface of the fabric. Paint the end of the canoe along the crack with the mixing stick or a small brush, or inject it with a syringe, or use a plastic spreader or stiff brush to fill the crack. Mix a small batch of G/Flex 650 Epoxy. Apply epoxy to the crack with a syringe or plastic spreader.

Mix an appropriate amount of G/Flex 650 Resin and 406 Filler in a ratio of 8:1 minimum bevel to the percentage of each epoxy in the blend.

A DUTCHMAN is a wood splice used to repair damaged sections of wood timbers. We recommend creating an 8:1 mix of epoxy to provide adequate glue strength to maintain a structural integrity.

Appliances and recreational vehicles often have holes which can be plugged with a small amount of epoxy on the reverse page.

Note to use 7-9 hours before removing excess cured epoxy and shaping the joint with a sanding belt. Mix additional epoxy to fill the beveled joint. Allow 7–9 hours to cure before removing excess cured epoxy and shaping the joint with a sanding belt.

Mix a small batch of G/Flex 650 Epoxy. Apply epoxy to the crack with a syringe or small plastic spreader. Force the epoxy into the crack. Mix a small batch of G/Flex 650 Epoxy to repair fasteners and hardware, especially fasteners subject to shock or vibration. Use G/Flex 650 Epoxy to install new fasteners and hardware, especially if the hole is metal.

Mix an appropriate amount of G/Flex 650 Primer with 400 Colloidal Silica Filler to a mayonnaise consistency. Use G/Flex 650 Primer to create a mayonnaise consistency into the hole and around the perimeter of the hole.

To blend G/Flex 650 with 105 Resin-based epoxies, you will need to change the volume portion to the percentage of each epoxy in the blend. Blend G/Flex 650 Epoxy 400 Filler with 105 Resin with the aid of a stirrer.

LAMINATING multiple layers of wood strips is a great way to create custom-shaped laminar boards for frames, stakes, legs, frames, legs, rails, and trim. Laminated lumber is stronger and more stable than steam or bent wood. Glue strips using the preparation and bonding technique discussed below.

Bonding fasteners

Mix an appropriately sized batch of G/Flex 650 thickened with 400 Colloidal Silica Filler to a mayonnaise consistency. Use G/Flex 650 Primer to provide adequate glue strength to maintain a structural integrity.

Mix a small batch of G/Flex 650 Epoxy. Apply epoxy to the crack with a syringe or plastic spreader. Force the epoxy into the crack. Mix a small batch of G/Flex 650 Epoxy. Apply epoxy to the crack with a syringe or plastic spreader. Force the epoxy into the crack. Mix a small batch of G/Flex 650 Epoxy. Apply epoxy to the crack with a syringe or plastic spreader. Force the epoxy into the crack. Mix a small batch of G/Flex 650 Epoxy. Apply epoxy to the crack with a syringe or plastic spreader. Force the epoxy into the crack. Mix a small batch of G/Flex 650 Epoxy. Apply epoxy to the crack with a syringe or plastic spreader.